



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-500
Job Sheet 176657



Part No: SWA10A-500

Job Qty: 40 ea

Part Name: Semi-Rings



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/27/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A-500 Rev 4 IPP Rev A 18.01.10 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	40 Ea	5/11/18	5/11/18	0.00	0.00	Start Up Machining-4		18-5-5
95	CNC Lathe	40 pcs	5/11/18	5/11/18	0.00	8.00	MORI NLX		14.5
100	QC	40 pcs	5/11/18	5/11/18	0.00	0.00	QC2 Machining-4		18/05/18
110	CNC Vertical Machining	40 pcs	5/11/18	5/11/18	0.00	8.00	MORI NV5000-1		
120	QC	40 pcs	5/11/18	5/11/18	0.00	0.00	QC2 Machining-2		
130	QC	40 pcs	5/11/18	5/11/18	0.00	0.00	QC8 Machining-4		
140	Packaging	40 pcs	5/11/18	5/11/18	0.00	0.00	Packaging3-2		
150	QC21-SA	40 Ea	5/11/18	5/11/18	0.00	0.00	QC21		

Part Op 95 - 1-Machine as per folio FC054 FOLIO REV: _____

DWG REV: _____

2-Deburr _____

Descriptions: 110 - 1-Machine as per folio FC054 FOLIO REV: _____

DWG REV: _____

2-Deburr _____

140 - ***NOTE*** 1 RING IS TWO HALVES.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R2.750	17-4 SS H1150 Round Bar 2.750"	1.9600 ft (.049 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R2.750	2	6	0
	5049433	1.91		

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 4/27/18 8:21 AM Dart.lajeunesse.marie

Container No: S068691



Part: SWA10A-500

Job No: 176657

Serial No/Batch: S068691

Revision: 4

Inspector:

Date: 05/05/18

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



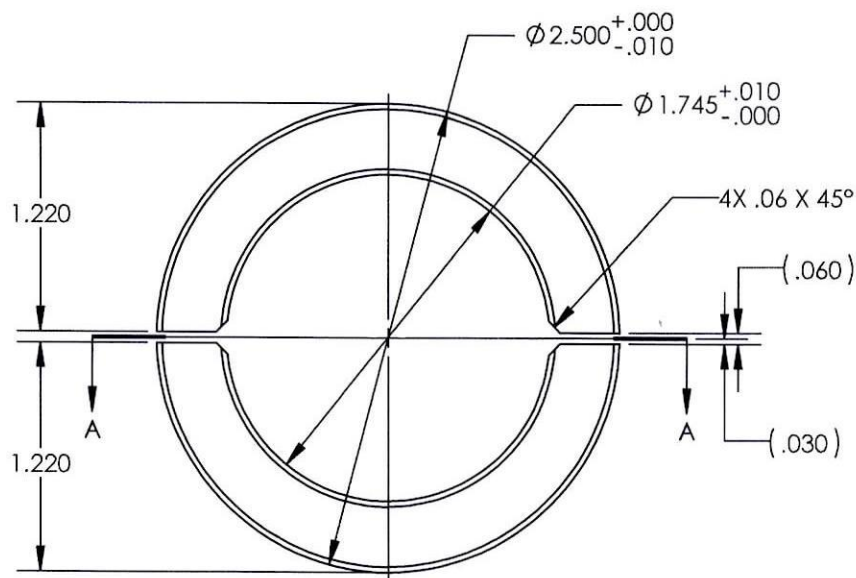
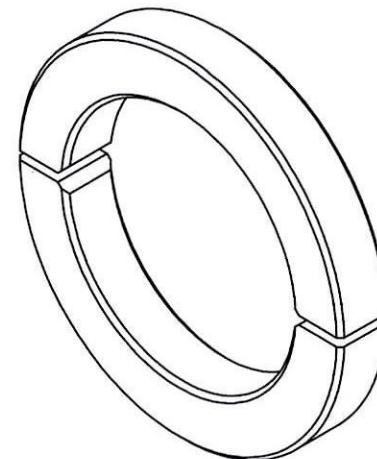
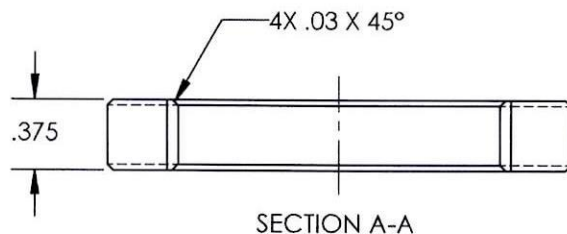
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Work Order update only ☐

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OTHER : _____					

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
3		AS DRAWN BY CANAM	11/12/2012	JAG
4	16-0242	UPDATED TO NEW STANDARDS. CH'D DIM WAS Ø2.500 IS Ø2.500+.000/-0.010, WAS Ø1.745 IS Ø1.745+.010/-0.000; ADDED DIM 4X .06 X 45°. CH'D MATL WAS SS 17-4, H1150 IS SS 17-4, H1150/H1075.	12/2/2016	SM



DART AEROSPACE	
TITLE SEMI - RINGS	
DWG NO. SWA10A-500	REV 4
MAT'L 17-7, H 1150/H1075	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125✓
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 x 45° OR .016R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 2/22/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-500	1	SEMI - RINGS	17-7, H 1150/H1075	